

# Work Order ID 80497

\*80497\*

Page 1

February-21-12 3:11:28 PM

Item ID: D4544-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Retainer, Center

Stop \*NS2\*

Start Date: 21/02/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: 11.5

Date: 12/02/12 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4544

A

100

0.00

\*100\*

Mill Conv

Memo

0.00

Conventional Milling Machine

mill as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00

\*110\*

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

\*120\*





HandFinish

Memo

0.00

Hand Finishing

**Dart Aerospace Ltd**

W/O: 80497		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12.04.03	100	PART FORMED TO FIT AIRCRAFT 2 10° BEND RT IN TABS 	 380497 04544-1	12.04.03	1	 12.04.03 081042	 12.04.03

Part No: D4544-1    PAR #: \_\_\_\_\_    Fault Category: \_\_\_\_\_    NCR: Yes No    DQA: \_\_\_\_\_    Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_    Disposition: \_\_\_\_\_    QA: N/C Closed: \_\_\_\_\_    Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action    Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80497

\*80497\*

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February-21-12 3:11:28 PM

Item ID: D4544-1

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Retainer, Center

Start Date: 21/02/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC3- Inspect Part Finish

0.00

\*130\*

QC

Memo

0.00

Quality Control

12/3/2012

140

Identify as per dwg & Stock Location: ST 241 B

0.00

\*140\*

Packaging

Memo

0.00

Packaging

SP 12-03-2

150

QC21- Final Inspection - Work Order Release

0.00

\*150\*

QC

Memo

0.00

Quality Control

MLJ 12/03/02

12-03-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 80497

\*80497\*

Parent Item: D4544-1

\*D4544-1\*

Parent Item Name: Retainer, Center

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 12.01.17 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X02.00 0		Purchased	No				f	42.2100		7.9			

\*M6061T6B0 250X02 000\*

\*\*

6061-T6 Bar .250 X 2.00

Location

Loc Qty

Loc Code

MAT001

42.21

107436

42.21

857 AA 12-3-01

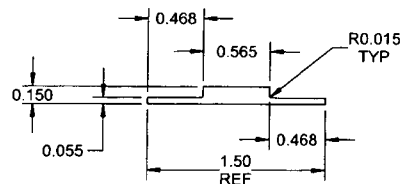
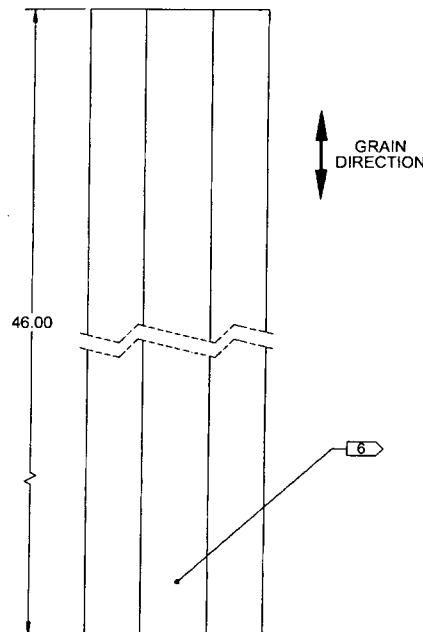
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4544-1 RETAINER, CENTER**

80497 M.C.J  
12/02/21

RELEASED  
2012-02-16  
MP

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET OR BAR  
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR QQ-A-250/11 OR AMS-QQ-A-250/11 (OR AMS 4025/4027)  
OR ASTM B211 OR ASTM B221 OR ASTM B209  
REF DART SPEC. M6061T6S OR M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4544-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.61 lbs

REV.	NEW ISSUE	DESCRIPTION	CP	12.01.09
DESIGN			BY	DATE
DRAWN				
CHECKED	ASS			
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	12.01.09			

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4544</b>	REV. A
TITLE <b>RETAINER, CENTER</b>	SCALE NTS
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



